Dart Aerospace Ltd. Monday, 3/19/2007 8:17:25 AM Kim Johnston User: **Process Sheet** : STOP **Drawing Name** : CU-DAR001 Dart Helicopters Services Customer Job Number : 31270A **Estimate Number** : 10731 : NA **Part Number** : D23243 P.O. Number S.O. No. : 11A : D2324 REV. C **Drawing Number** : 3/19/2007 This Issue : N/A Project Number Prsht Rev. . : SMALL /MED FAB ; C First Issue **Drawing Revision** :NA : 30139A Material Previous Run : 4/12/2007 Qty: 20 Um: Due Date Written By Checked & Approved By Reformat; Incorporated D2324-3 & Comment : Est: E 03.02.28 D2324-5 KJ/RF **Additional Product** Job Number: Description: Seq. #: Machine Or Operation: 6061-T6 Bar .75" x .75" 1.0 M6061T6B0750X00750 Comment: Qty.: 17100742=19 0.5565 f(s)/Unit Total: 11.1300 f(s) BAND SAW 2.0 Comment: BAND SAW Cut blanks: (0.75" x 0.75") x 5.75" Long Bar 3.0 HAAS CNC VERTICAL MACHINING #1-Comment: HAAS CNC VERTICAL MACHINING #1 1- Machine as per Folio D2324-3 and Dwg D2324 2- Deburr and Tumble to remove sharp edges

Identify as D2324-3

INSPECT PARTS AS THEY COME OFF MACHI

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SECOND CHECK



Comment: SECOND CHECK

4.0

5.0

QC2

QC8

Each

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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Part No:	PAR #:	Fault Category:	NCR: Yes(N	o) DQA:	Date: 07/03/2
			QA: N/C	Closed:	Date:

NCR: WORK ORDER NON-CONFORMANCE (NCR)						:		
		Description of NC		Corrective Action Section B		Verification	A	
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NOTE: Date & initial all entries

Monday, 3/19/2007 8:17:25 AM Date: Kim Johnston ⊌ser: **Process Sheet** Drawing Name: STOP Customer: CU-DAR001 Dart Helicopters Services Part Number: D23243 Job Number: 31270A Job Number: Seq. #: Description: Machine Or Operation: HAND FINISHING1 HAND FINISHING RESOURCE #1 Comment: HAND FINISHING RESOURCE #1 07-0326 Acid etch and Alodine as per QSI 005 4.1 INSPECT POWDER COAT/CHEMICAL CONVERSION 7.0 QC3 Comment: INSPECT ALODINE PACKAGING 1 8.0 وفريات Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 9.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE U Dio3,28 Job Completion

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W/O:		WORK ORDER CHANGES									
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Part No:	PAR #:	Fault Category:	NCR: Yes No	DQA:	_ Date:	
			QA: N/C	Closed:	_ Date: _	
NCR:	V	ORK ORDER NON-CONFORI	MANCE (NCR)		7 1	
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NCR:	: World Order Order Order (NOIL)							
i		Description of NC		Verification	A	A		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31270A
Description: Strut	Part Number:	D2324-3
Inspection Dwg: D2324 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.257	+/-0.010	Ø 0.259				
Ø0.191	+/-0.010	80.193				
0.750	+/-0.010	6.748				
0.375	+/-0.010	0.370				
1.875	+/-0.010	1.973	/			
5.250	+/-0.010	5,244				
5.625	+/-0.010	5.418				
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Measured by:	Audited by:	J.L	Prototype Approval:	N/A
Date: 07/63/22	Date:	07/03/23	Date:	N/A

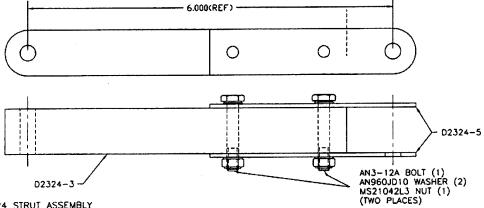
Rev	Date	Change	Revised by	Approved
Α	04.06.10	New Issue P/O D2324-1	KJ/JLM ,	-1
В	06.03.08	Dwg Rev changed	KJ/JLM	
			7()	



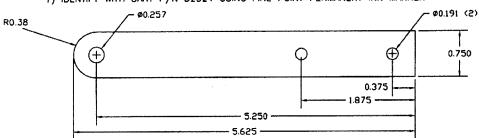
	SIGN WILLIAMS	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
	CKED,	APPROVED_	DRAWING NO.	REV. C
	#	- # -	D2324 SHEET	1 OF 1
DAT	E		TITLE	SCALE
04	.12.14		STRUT	
Α		94.11.08	NEW ISSUE	
В		96.05.07	UPDATE MATERIALS	

RELEASED 04.12.16

04.12.14 UPDATE NOTES С



D2324 STRUT ASSEMBLY 1) IDENTIFY WITH DART P/N D2324 USING FINE POINT PERMANENT INK MARKER



D2324-3

6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75 1) MATERIAL:

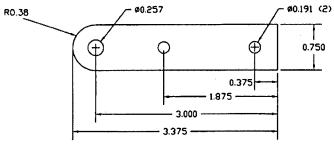
(REF DART SPEC. M6061T6B0.750X00.750)

AGID ETCH AND ALODINE PER DART QSI 005 4.1 2)_EINISH: POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3

3) BREAK ALL SHARP EDGES 0.005 TO 0.015

4) ALL DIMENSIONS ARE IN INCHES

5) ALL TOLERANCES ARE PER DART OSI 018 UNLESS OTHERWISE NOTED



D2324-5

1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 16 GAUGE (0.063 THICK) (REF DART SPEC. M304S16GA)

2) FINISH: POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3

3) BREAK ALL SHARP EDGES 0.005 TO 0.015

4) ALL DIMENSIONS ARE IN INCHES

5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. 31270 A